

Work Order ID 64144

PRELIMINARY ISSUE

Thursday, November 25, 2010 3:58:03 PM

Page 1

Item ID: D4298-024

Accept

Setup

Start



Revision ID: PPELIM

Stop



Item Name: Serrated Adjustment Washer

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:



Reference:

Approvals:

Process Plan:



Date: 10/11/26

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4298

PAT Rev. A

100



Doosan

Memo

0.00

8

Doosan Lathe

10/12/14

110



QC2- Inspect parts off machine FAI/FAIB

0.00

8

QC

Quality Control

Memo

0.00

10/12/14

120



QC8- Inspect parts - second check

0.00 - inspected by Era - 024

Dry run

QC

Quality Control

Memo

0.00

- Add by SLM 12 hole to
be transferred after assembly

8/10/12/14

(AS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64144

Page 2

Thursday, November 25, 2010 3:58:03 PM

Item ID: D4298-024

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Serrated Adjustment Washer

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: G-A

0.00

Packaging

Packaging

Memo

0.00

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

Sp 10/12/15

(8)

MP
10-12-15

POSITIVE RECALL
 EFFECTIVE 10-11-29 AUTH AL
 RELEASED J DATE 10-12-17
 checked stock qty 4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 25, 2010 3:58:06 PM

Page 1

Work Order ID: 64144



Parent Item: D4298-024



Parent Item Name: Serrated Adjustment Wash

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 10.11.25 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M606116R1.000

Purchased

No

f

13.6800

0.0161

0.016947

ROUND BAR 1.00"

M303R 1.00

Location	Loc Qty	Loc Code
MAT	11.5	
115609	11.5	
MAT013	2.18	
108876	1.88	
113457	0.3	

10.12.13

115774

.34

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64144
Description: Scratched Washers	Part Number:	14298-024
Inspection Dwg: 14298 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

10

First Article

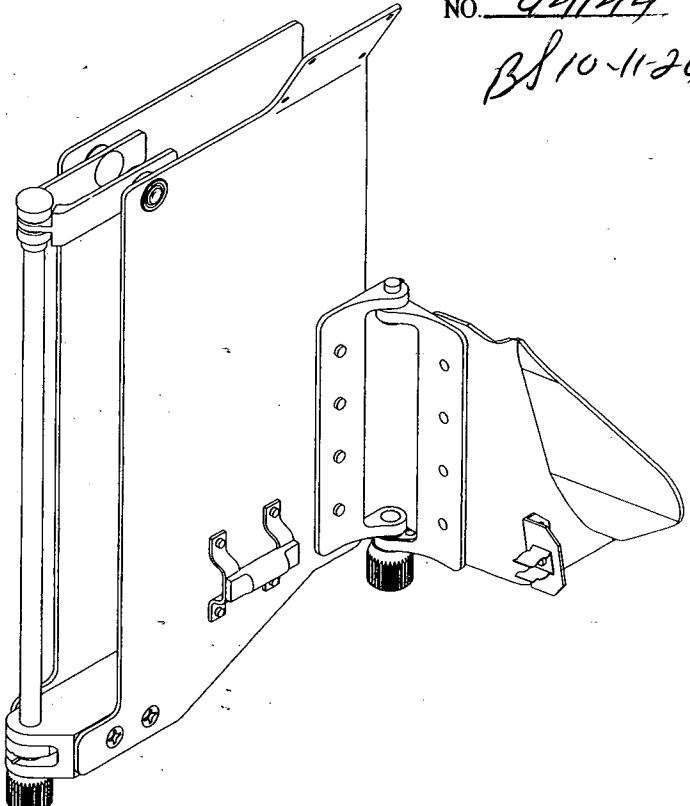
Prototype

Measured by:	<u>SJ</u>
Date:	<u>10/12/14</u>

Audited by:	S
Date:	10/12/93

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64144

B810-1126

REVISION

LETTER	DRFTSMN	DATE	DESCRIPTION	APPROVED	DATE
IR	DNN	9/8/10	INITIAL RELEASE.		
A	DNN	11/12/10	MAT'L CHG. FOR ITEMS 8 THRU 20; CHG. GRIP ON 20; UPDATED P/N'S.		

4			(37) AN426AD4-()	RIVET				
4			(36) AN426AD3-()	RIVET				
1			(35) C-CLIP					
2			(34) MS27980-6B	SOCKET, SNAP FASTENER				
2			(33) MS27980-1B	BUTTON, SNAP FASTENER				
1 1			(32) MS27980-9B	POST, SNAP FASTENER				
1 1			(31) MS27980-7B	STUD, SNAP FASTENER				
4	(30)	MS24693-C246	SCREW					
1	(29)	MS171441	PIN, SPRING		(ALT P/N NAS561C2-13)			
1	(28)	MS24665-103	COTTER PIN					
1	(27)	MS20392-3C15	PIN, STRAIGHT HEADED					
3	(26)	NAS1149D0332J	WASHER					
3	(25)	MS27039C1-09	SCREW					
1 1 1	1	(24) -024	SERRATED ADJUSTMENT WASHER	STAINLESS STEEL				
	1	(23) -023	PIN	STAINLESS STEEL				
	1	(22) -022	PIN TOPPER	STAINLESS STEEL				
	1	(21) -021	MACHINE BOLT	STAINLESS STEEL				
1	2	(20) -020	KNOB	6061-T6 ALUM.				
		(19) -019	MACHINED OUTER	6061-T6 ALUM.				
	1	(18) -018	MACHINED INNER	6061-T6 ALUM.				
	2	(17) -017	CLIP STOP MOUNT	6061-T6 ALUM.				
	1	(16) -016	CLIP STOP	6061-T6 ALUM.				
	1	(15) -015	CLIP ANGLE	.050	6061-T6 ALUM.			
	1	(14) -014	HINGE	6061-T6 ALUM.				
	1	(13) -013	HINGE	6061-T6 ALUM.				
	1	(12) -012	HINGE	6061-T6 ALUM.				
	1	(11) -011	HINGE	6061-T6 ALUM.				
	1	(10) -010	FIXING BRACKET	.093	LEXAN			
	1	(9) -009	PLATE	.080	6061-T6 ALUM.			
	1	(8) -008	PLATE	.080	6061-T6 ALUM.			
	1	(7) -007	MACHINED OUTER SUB-ASSY					
	1	(6) -006	MACHINED INNER SUB-ASSY					
	1	(5) -005	HINGE SUB-ASSY					
	1	(4) -004	FIXING BRACKET SUB-ASSY					
	1	(3) -003	PLATE SUB-ASSY					
	1	(2) -002	PLATE SUB-ASSY					
	1	(1) -001	CHART HOLDER ASSY					
087-086-085-084-083-082-081	ITEM NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC.	ZONE	
NO. REQ'D PER ASSY.								

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UNLESS OTHERWISE SPECIFIED	DRFTSMN	D. NELSON	9/8/10	TITLE
X.± 1	CHECK			SINGLE PILOT VFR
XX.± .03	STRESS			CHART HOLDER, AW139
XXX.± .010	PROJ. ENGR.			
ANGLES +1/4	HEAT TREAT		C	SCALE NONE
FINISH	Era Helicopters LLC		DWG. NO. 13939-1-290	REV. A
			SHT. 1 OF 10	

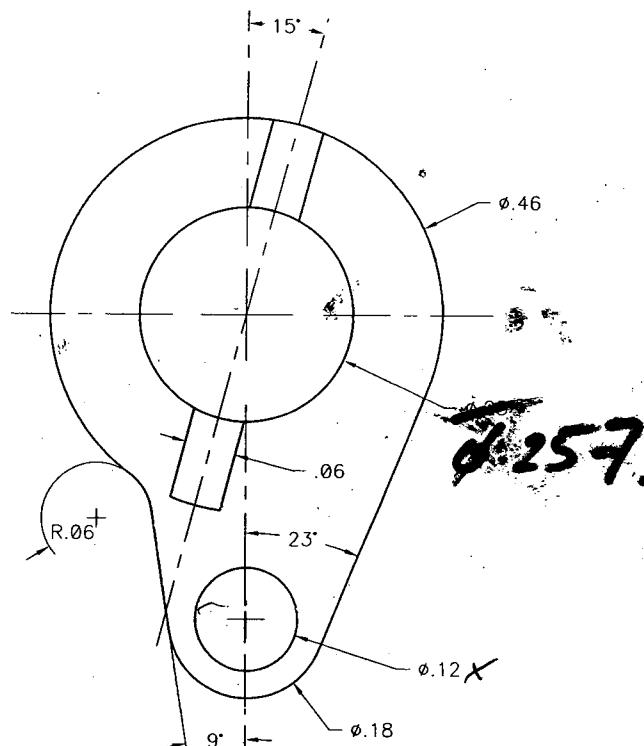
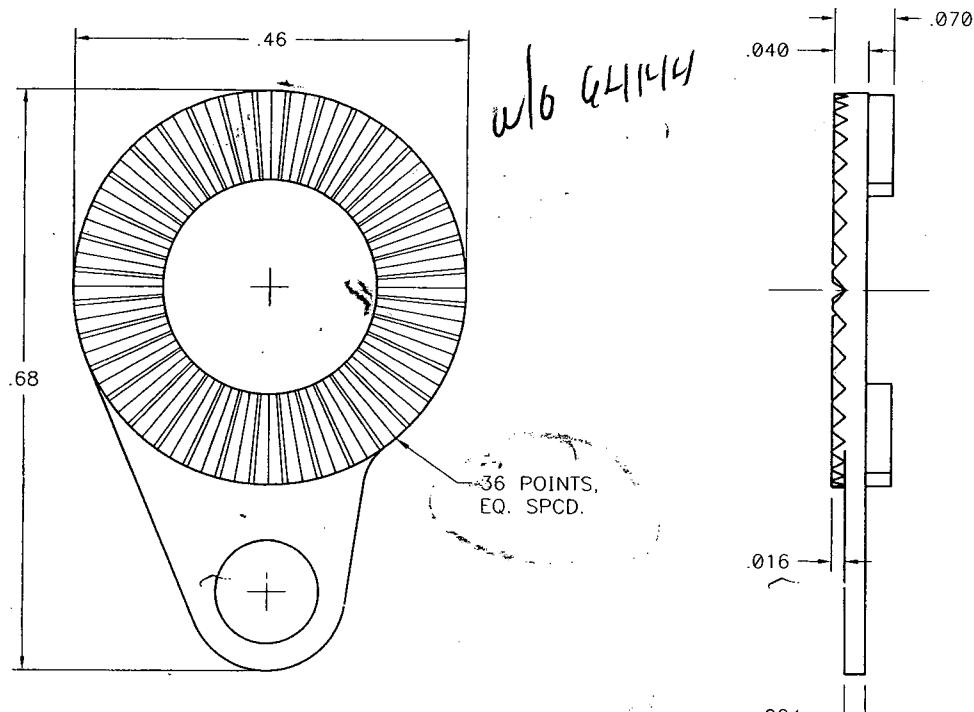
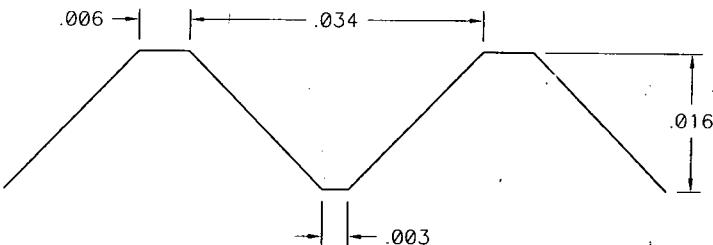
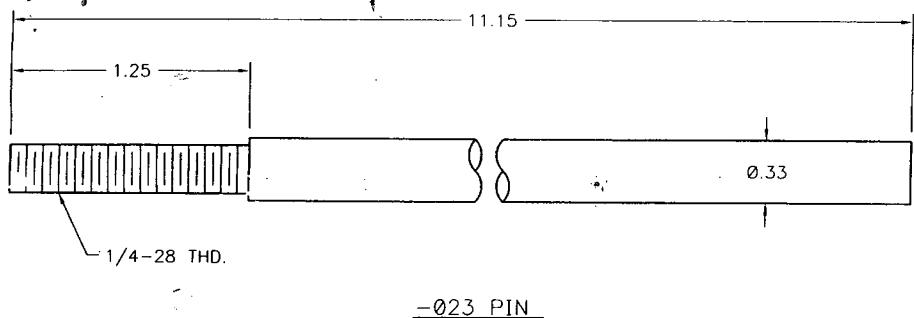
W/O:		WORK ORDER CHANGES					
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Era Helicopters LLC

TITLE
SINGLE PILOT VFR
CHART HOLDER, AW139

SIZE
C

DWG. NO.
13939-1-290
SHT 10 OF 10

REV.
A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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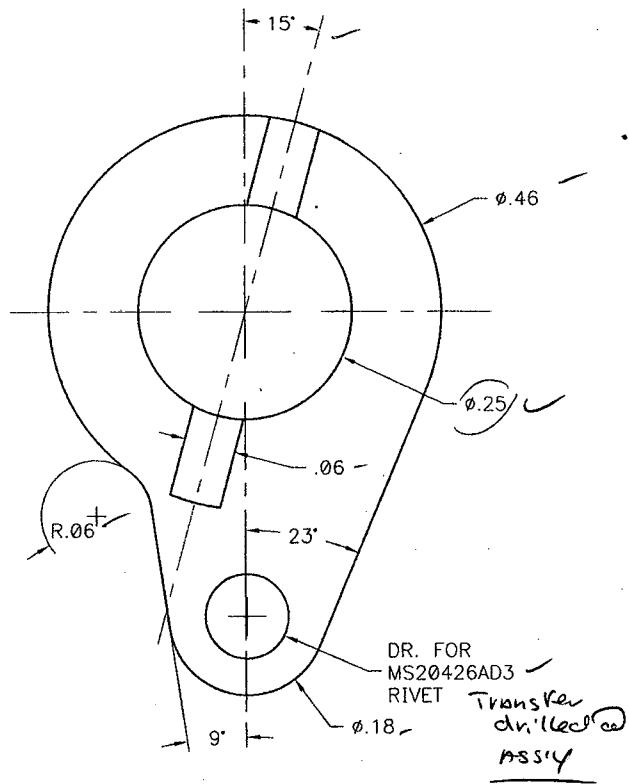
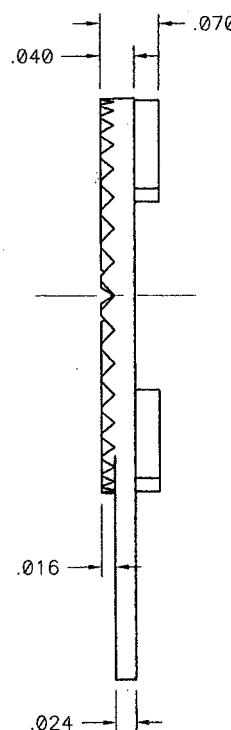
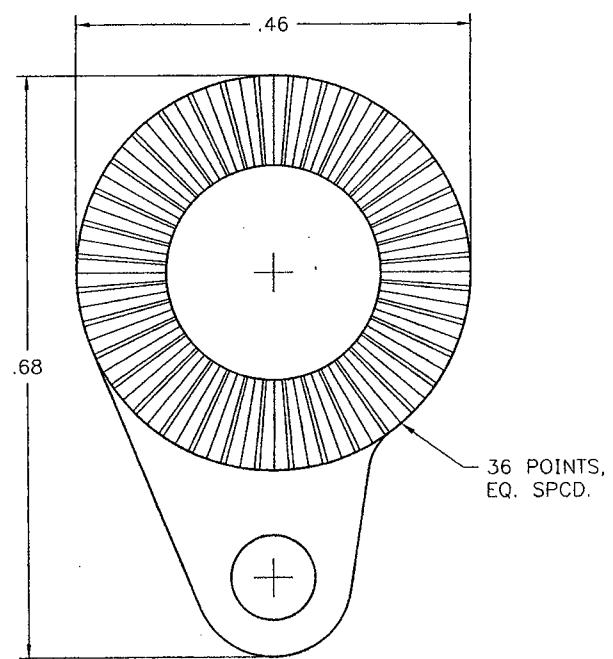
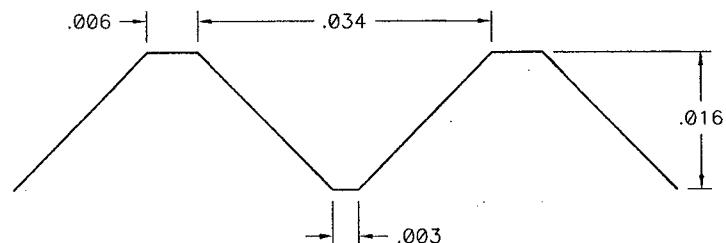
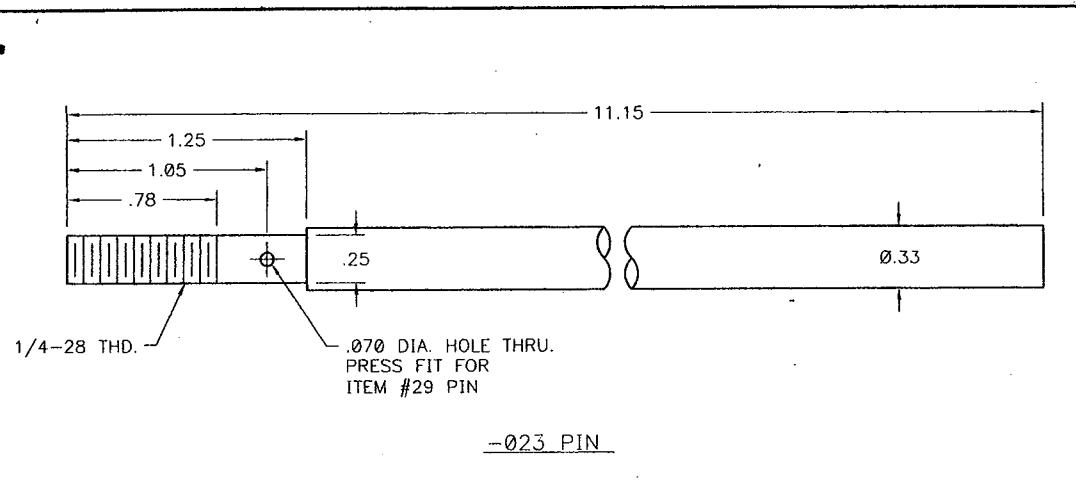
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DART P/N	ERA P/N	Description
D4298-001	13939-1-290-001	CHART HOLDER ASSY
D4298-002	13939-1-290-002	PLATE SUB-ASSY
D4298-003	13939-1-290-003	PLATE SUB-ASSY
D4298-004	13939-1-290-004	FIXING BRACKET SUB-ASSY
D4298-005	13939-1-290-005	HINGE SUB-ASSY
D4298-006	13939-1-290-006	MACHINED INNER SUB-ASSY
D4298-007	13939-1-290-007	MACHINED OUTER SUB-ASSY
D4298-008	13939-1-290-008	PLATE
D4298-009	13939-1-290-009	PLATE
D4298-010	13939-1-290-010	FIXING BRACKET
D4298-011	13939-1-290-011	HINGE
D4298-012	13939-1-290-012	HINGE
D4298-013	13939-1-290-013	HINGE
D4298-014	13939-1-290-014	HINGE
D4298-015	13939-1-290-015	CLIP ANGLE
D4298-016	13939-1-290-016	CLIP STOP
D4298-017	13939-1-290-017	CLIP STOP MOUNT
D4298-018	13939-1-290-018	MACHINED INNER
D4298-019	13939-1-290-019	MACHINED OUTER
D4298-020	13939-1-290-020	KNOB
D4298-021	13939-1-290-021	MACHINE BOLT
D4298-022	13939-1-290-022	PIN TOPPER
D4298-023	13939-1-290-023	PIN
D4298-024	13939-1-290-024	SERRATED ADJUSTMENT WASHER

RELEASED
2010-12-15
[Signature]

A	NEW ISSUE		SC	10.12.15	
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	SC				
CHECKED	<i>JW</i>	DRAWING NO.			SHEET 1 OF 1
MFG. APPR.	<i>EG</i>	D4298			
APPROVED	<i>JW</i>	TITLE			
DE APPR.	<i>-</i>	CHART HOLDER (AW 139)			NTS
DATE	10.12.15		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



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TITLE: SINGLE PILOT VFR
CHART HOLDER, AW139
SIZE: C
DWG. NO. 13939-1-290
REV. D
SHT 10 OF 10